



Dart Aerospace Ltd.
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D135-751-011
Job Sheet 179634



Part No: D135-751-011

Job Qty: 1 ea

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Job Created: 6/20/18

Due Date: 8/2/18

Type: SOLD

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Jesse White

Description:

Note: DWG DSI 9661 REV A, D3507 REV D IPP Rev:A 44353 New Issue JLM IPP Rev:B 06-12-18 As per Rev B
JLM IPP Rev:C 07-12-11 ECN 1036 as per revB DD IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC
verf DD IPP Rev E 10.02.22 per PAR 09-043 EC verified: DD IPP Rev:F 10.06.09 remove seq110 DD verf:EC
IPP Rev G 10.09.17 added D3507-1-bent EC verified:DD IPP REV:H 13.12.11 ECN13-619/ CHG002 DD
VERF:JLM

Ship Via:



Container No: S091474



Part: D135-751-011

Job No: 179634

Serial No/Batch: S091474

Revision:

Inspector:

Exp Date:

Instructions:

FAA STC SR01709SE 15/10/20, TC LoA RDIMS-9661680-v1 14/0

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Is

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		8/2/18	0.00	0.00	Start Up Skid tubes-1		DD
120	Skid tubes	1 pcs		8/2/18	0.00	0.80	Skid tubes-1		DD DAS 38
140	QC	1 pcs		8/2/18	0.00	0.00	QC5		2018-07-20
150	HandFinish	1 pcs		8/2/18	0.00	0.33	HandFinish1		BB DAS 38
160	QC	1 pcs		8/2/18	0.00	0.00	QC7-1		SA 18-07-25
170	Skid tubes	1 pcs		8/2/18	0.00	1.00	Skid tubes-1		BB DAS 38
180	QC	1 pcs		8/2/18	0.00	0.00	QC10		BB
185	HandFinish	1 pcs		8/2/18	0.00	0.10	HandFinish6		SA 18-07-25
187	QC	1 pcs		8/2/18	0.00	0.00	QC7-1		BB
190	Skid tubes	1 pcs		8/2/18	0.00	0.77	Skid tubes-1		BB
200	QC	1 pcs		8/2/18	0.00	0.00	QC5		SA 18-08-1
210	HandFinish	1 pcs		8/2/18	0.00	0.08	HandFinish2		SA 18-08-1
215	Outsource	1 pcs		8/2/18			ATE003-VC	5	WIK
220	SprayPaint	1 pcs		8/2/18	0.00	0.25	Spray Paint		SA 18-08-07
230	QC	1 pcs		8/2/18	0.00	0.00	QC14		SA 18-08-07
260	HandFinish	1 pcs		8/2/18	0.00	0.74	HandFinish4		BE 18-08-02
270	QC	1 pcs		8/2/18	0.00	0.00	QC5		SA 18-08-03
280	Packaging	1 pcs		8/2/18	0.00	0.00	Packaging1-1		AUG 03 2018
290	QC	1 pcs		8/2/18	0.00	0.00	QC4		DAS 21
300	Packaging	1 pcs		8/2/18	0.00	0.00	Packaging3-1		9-88 AUG 03 2018
305	DC	1 pcs		8/2/18	0.00	0.00	DC		DAS
310	QC21-FG	1 Ea		8/2/18	0.00	0.00	QC21		AUG 03 2018

Part Op 120 - 1-Cut Aft end as per dwg D3507 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 4-Locate DT8870 & Drill Descriptions: Ground wire hole on top of Tube. 6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill All X-Bolt holes using #30" drill.****DO NOT OPEN AFT CAP HOLES***** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using DT8892.Open all wearplate holes to 0.297" 9-Open ground wire hole .297" section E-E 10-Open Aft & Fwd Cap holes using .208" drill. 11-Bore out aft end of tube as per Dwg D3507 & Detail "B". 12- Section G-G holes must be laid out manually, open to #30. 13-Deburr holes.

170 - 1-Open X-Bolt holes to .375"(1 Places) & .500"(2Places) as per Dwg D3507. and section G-G to .750" (2 places) 2-Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI 015 start time : _____ end time: _____ 5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Deburr Rivet holes.

185 - RE-ALODINE ONLY

190 - 1-Rivet D3506-1/-3 as per Dwg D3507.

210 - Touch-up alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220 - 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer Batch: _____ 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint Batch: _____

260 - 1- Install Wearplate & Ground Wire inserts as per Dwg D3507. 1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" 3-Install Wearplates as per Dwg D3507 , Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Scews where indicated on Dwg(Note #6) 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: 1138851

300 - Identify and pack for shipping as per PPP D135-751-011 PPP Rev: _____

305 - Photocopy bluefile & type labels per PPP D135-751-011 CHG002

sika flex 1138787 18/12.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3507-1-BENT	Skidtube Assembly EC135	1 Ea (1 ea)	90-Start up Operation	5089120
D3504-1	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	5077412
D3504-3	Crossbolt Spacer	1 Ea (1 ea)	170-Skidtubes	B105604
D3504-5	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	5071543
D3505-1	Web	1 Ea (1 ea)	170-Skidtubes	5076673
D3506-1	Doubler	4 Ea (4 ea)	190-Skidtubes	5070850
D3506-3	Doubler	2 Ea (2 ea)	190-Skidtubes	5131267
MS20601-AD4W3	Rivet	12 Ea (12 ea)	190-Skidtubes	5092687
ALS4-1032-225	Rivnut	1 Ea (1 ea)	260-HandFinish	5058138
ALS7-1032-130	Rivnut	38 Ea (38 ea)	260-HandFinish	5084123
AN3C4A	Bolt	31 Ea (31 ea)	260-HandFinish	5050186
AN3C5A	Bolt	2 Ea (2 ea)	260-HandFinish	5057153
AN526C1032R10	Screw	2 Ea (2 ea)	260-HandFinish	5071664-2
D2965	Cap	1 Ea (1 ea)	260-HandFinish	5045482
D2965-3	Cap	1 Ea (1 ea)	260-HandFinish	F126369
D3492-1	Plug	4 Ea (4 ea)	260-HandFinish	5077552
D3492-3	Plug	4 Ea (4 ea)	260-HandFinish	5091848
D3492-7	Plug	2 Ea (2 ea)	260-HandFinish	F106110
D4918-047	Wearplate Aft	1 Ea (1 ea)	260-HandFinish	5089854
D4918-1	Wearplate Fwd	1 Ea (1 ea)	260-HandFinish	5089866
D4918-3	Wearplate Center Fwd	1 Ea (1 ea)	260-HandFinish	5081647
D4918-5	Wearplate Center Aft	1 Ea (1 ea)	260-HandFinish	5085862
NAS1149C0332R	Washer	33 Ea (33 ea)	260-HandFinish	5056493
NAS1611-007	O-Ring	2 Ea (2 ea)	260-HandFinish	F103697
NAS1611-010	O-Ring	4 Ea (4 ea)	260-HandFinish	5049970
NAS1611-013	O-Ring	4 Ea (4 ea)	260-HandFinish	5083560
AN3C4A	Bolt	8 Ea (8 ea)	280-Packaging	5040636
D3512-041	Wearplate	2 Ea (2 ea)	280-Packaging	5048557
NAS1149C0332R	Washer	8 Ea (8 ea)	280-Packaging	5049837

004828

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3507-1-BENT	1	0	0
170-Skidtubes	D3504-1	2	28	0
	D3504-3	1	26	0
	D3504-5	2	14	0
	D3505-1	1	4	0
190-Skidtubes	D3506-1	4	17	0
	D3506-3	2	8	0
	MS20601-AD4W3	12	1,163	0
260-HandFinish	ALS4-1032-225	1	4,460	0
	ALS7-1032-130	38	1,389	0
	AN3C4A	31	1,807	0
	AN3C5A	2	1,655	0
	AN526C1032R10	2	178	0
	D2965	1	80	0
	D2965-3	1	30	0
	D3492-1	4	272	0
	D3492-3	4	103	0
	D3492-7	2	35	0
	D4918-047	1	8	0
	D4918-1	1	9	0
	D4918-3	1	8	0
	D4918-5	1	9	0
	NAS1149C0332R	33	5,349	0
	NAS1611-007	2	286	0
	NAS1611-010	4	453	0
	NAS1611-013	4	349	0
280-Packaging	AN3C4A	8	1,807	0
	D3512-041	2	15	0
	NAS1149C0332R	8	5,349	0

Part Specifications

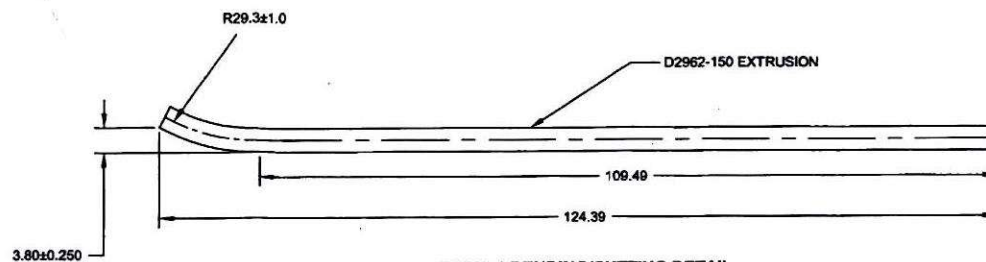
Specifications could not be found.

Plex 6/20/18 1:07 PM dart.white.jesse

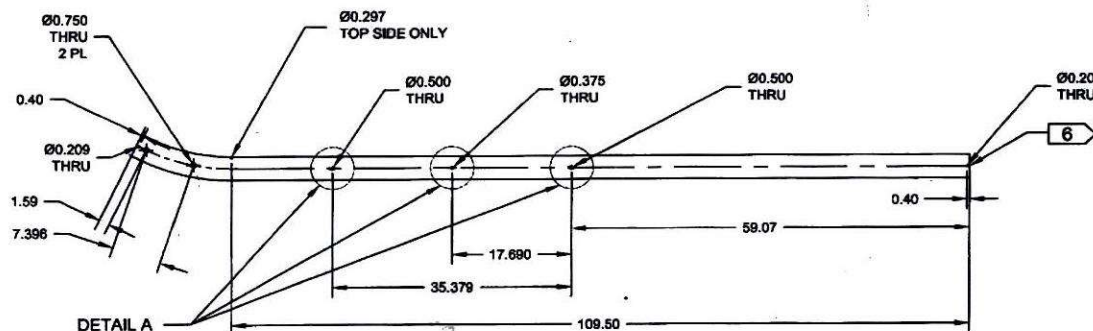
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D4918-1	WEARPLATE
1	D4918-3	WEARPLATE
1	D4918-5	WEARPLATE
1	D4918-047	WEARPLATE
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20801AD4W3	RIVET

GENERAL NOTES:

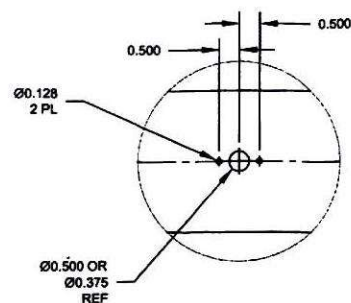
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB.
 STANDARD: PRIME (REF. 4.2 1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.
 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3.
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART BAN PER DART QSI 044 6.4 (VIBRATING STYLUS) ON I.D. OF TUBE
- 7) WEIGHT: 24.1 LB (FROM IIN-D135-751)
- 8) WELDING TO BE DONE PER DART QSI 004
- 9) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 10) USE DART DRILL TEMPLATE DT8898 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 11) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A
TYP. 6 PL
SCALE 3:10

D	REMOVE D3568-X GASKETS, D4918-X WAS D3508-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH. REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW		
DRAWN	DW		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	13.08.30		

DART AEROSPACE USA, INC
KENT, WA

DRAWING NO. D3507
REV. D
SHEET 1 OF 2

TITLE EC 135 SKIDTUBE
SCALE NTS

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10-12-2013

